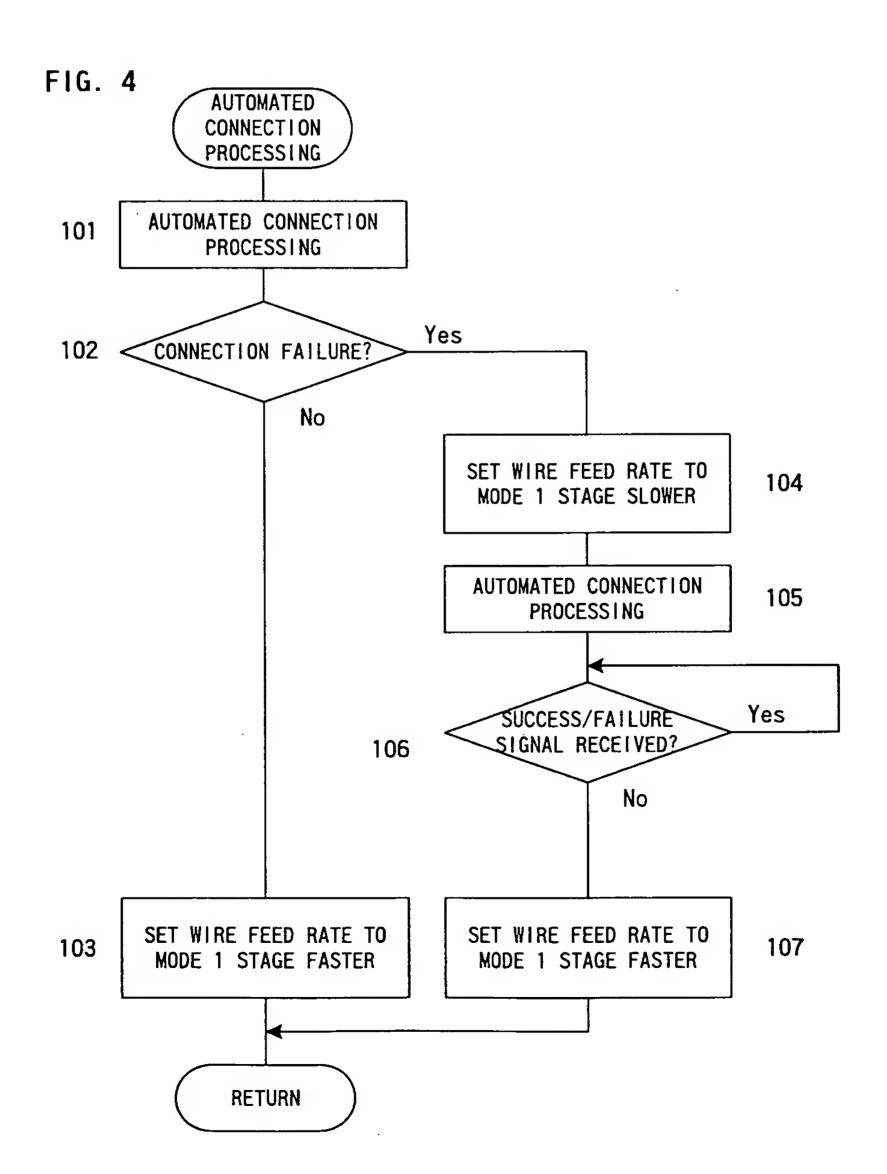
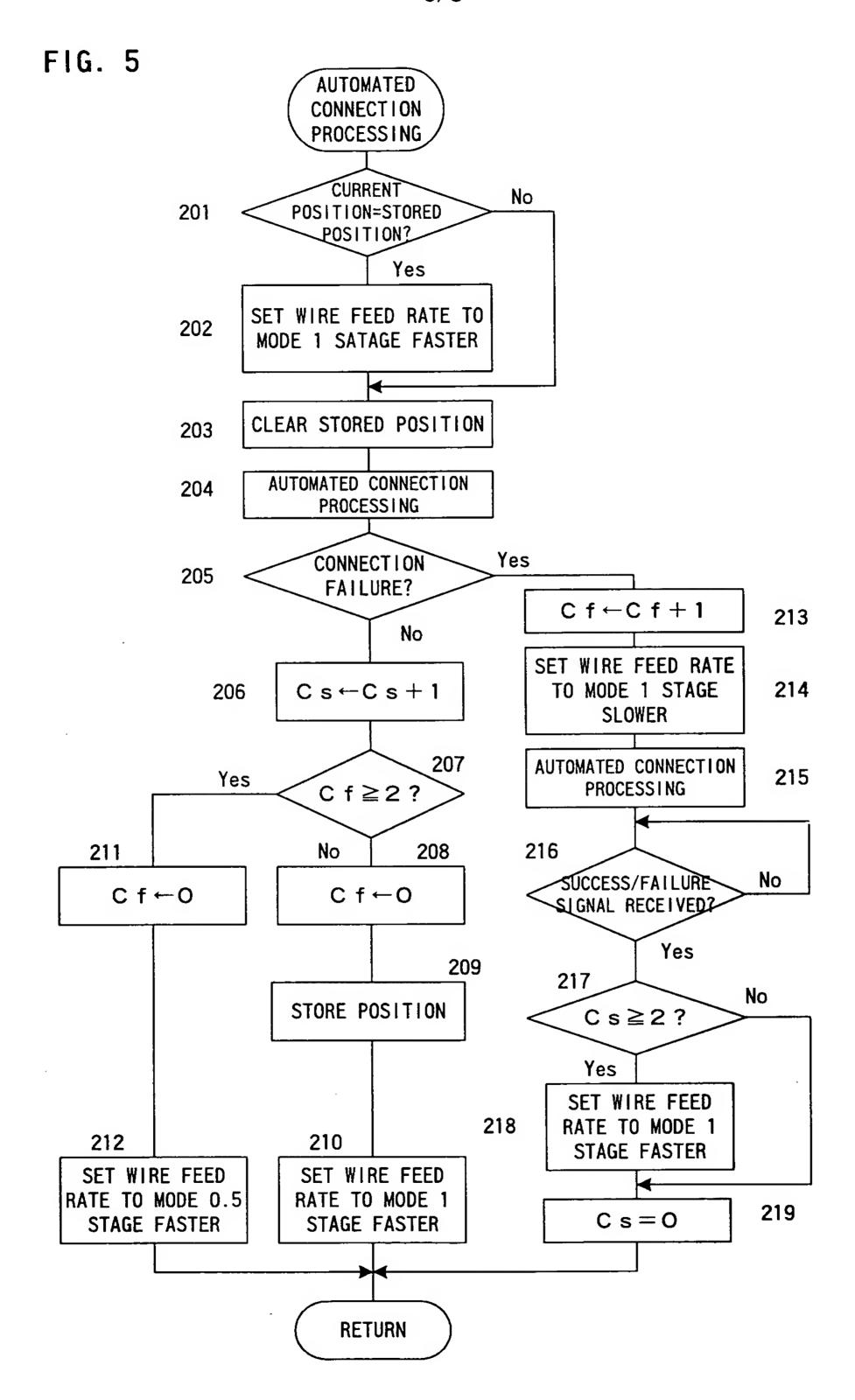
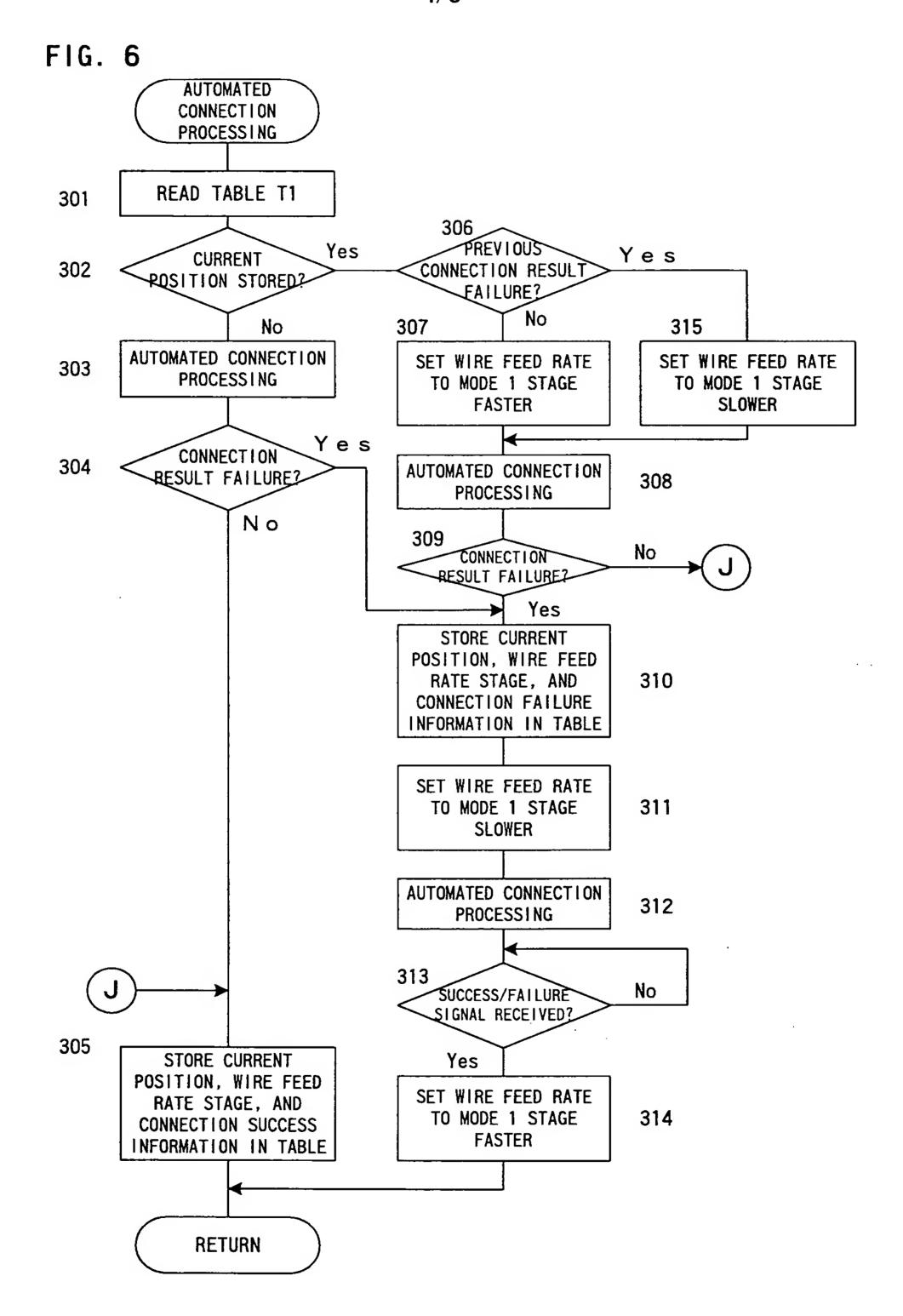


FIG. 3

|         | ROUGHING     | FINISH<br>MACHINING |  |  |
|---------|--------------|---------------------|--|--|
| SHAPE 1 | CONNECTION 1 | CONNECTION 5        |  |  |
| SHAPE 2 | CONNECTION 2 | CONNECTION 6        |  |  |
| SHAPE 3 | CONNECTION 3 | CONNECTION 7        |  |  |
| SHAPE 4 | CONNECTION 4 | CONNECTION 8        |  |  |







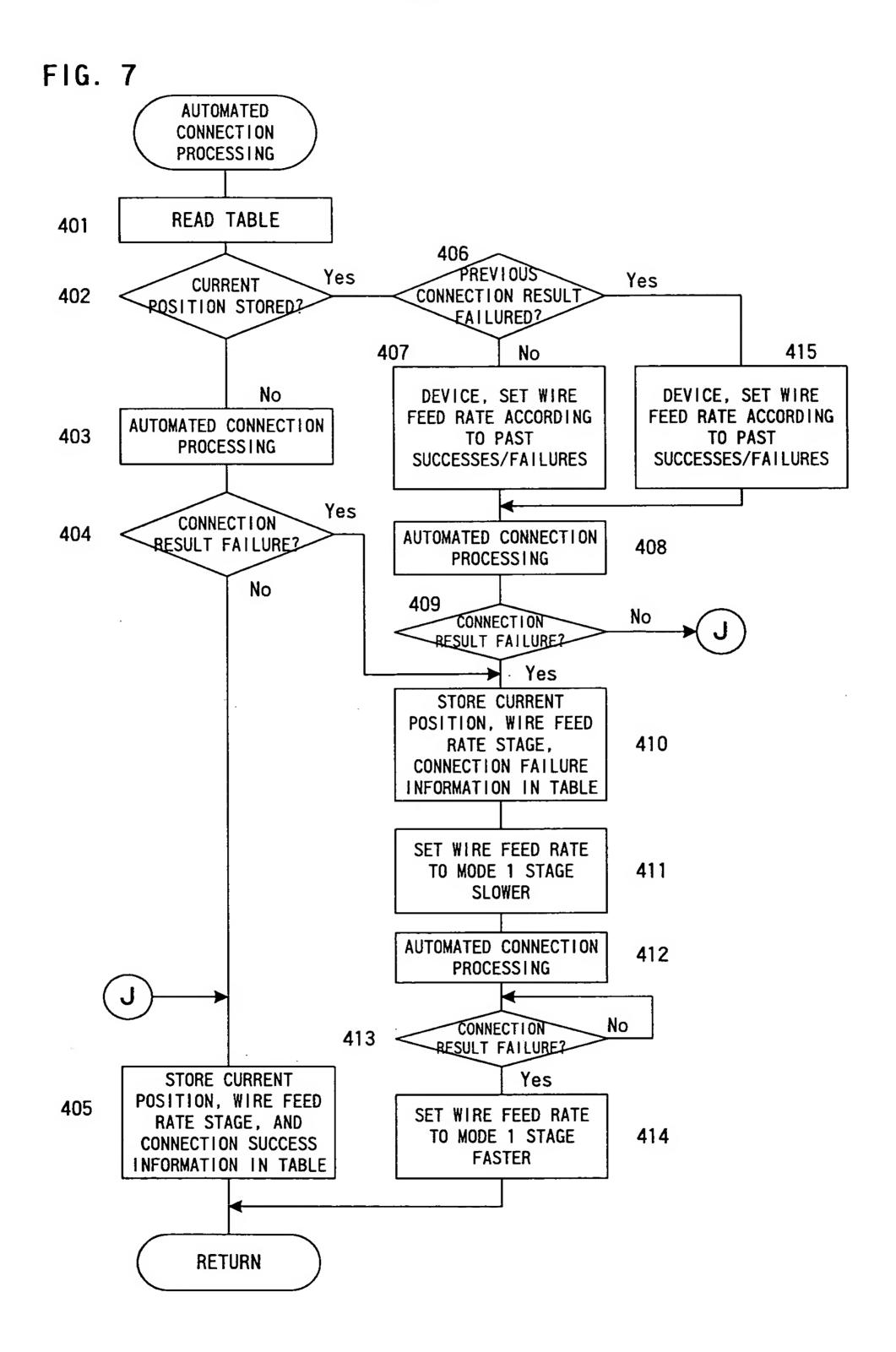


FIG. 8

|                       | T 1                  |                       |  |  |  |
|-----------------------|----------------------|-----------------------|--|--|--|
| THROUGH-HOLE POSITION | WIRE FEED RATE STAGE | SUCCESS(0)/FAILURE(1) |  |  |  |
| (x1, y1)              | 0                    | 0                     |  |  |  |
| (x2, y2)              | 0                    | 0                     |  |  |  |
| (x3, y3)              | 0                    | Ο                     |  |  |  |
| (x4, y4)              | 0                    | 0                     |  |  |  |

FIG. 9

|                       |                      | T 2                   | 2 |     |
|-----------------------|----------------------|-----------------------|---|-----|
| THROUGH-HOLE POSITION | WIRE FEED RATE STAGE | SUCCESS(0)/FAILURE(1) |   |     |
| (x1, y1)              | 0                    | 0                     | 0 | . 0 |
| (x2, y2)              | 0                    | 0                     | 0 | 0   |
| (x3, y3)              | 0                    | 0                     | 0 | 0   |
| (x4, y4)              | 0                    | 0                     | 0 | . 0 |